

ABSTRACT

5 A plastic lined steel pipe characterized by having
an adhesive layer on an inner surface of a steel pipe,
having a plastic layer on its further inner side, and
having an initial shearing adhesion strength between the
steel pipe and the plastic layer of 2.0 MPa or more, said
steel pipe being a steel pipe given substrate treatment
on its inner surface in advance, said substrate treatment
10 comprising forming a phosphate chemical treatment coating
treated for grain refinement, and preferably having an
epoxy primer layer between the steel pipe and the
adhesive layer.

15 A method for producing a plastic lined steel pipe
characterized by inserting a plastic pipe having an
outside diameter smaller than the inside diameter of the
steel pipe subjected to the substrate treatment and
having an adhesive layer on its outer surface into the
steel pipe, reducing the outside diameter of the steel
pipe so as to make the plastic pipe closing contact it,
20 and heating the result at a temperature not less than a
melt end temperature of the adhesive layer and less than
a melt start temperature of the plastic pipe.